

Date: Monday, 3/6/2006 1:55:52 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 26080	Part Number	: D29332
Estimate Number	: 10834	Drawing Number	: D2933 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 3/6/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Type	: MACHINED PARTS
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 25377	Material	: N/A
Written By	: See L.A. Comment Below	Due Date	: 3/31/2006
Checked & Approved By	: J.L. 06.03.06	Qty:	4 Um: Each
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D610f001	7075-T7351 2X6X6.25
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: M24890
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 1:55:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 26080

Part Number: D29332

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: SECOND CHECK	En oblat(2)
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	SAD 06/04/27 (4)
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	Tx oaloy/25 (4)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	10/6/4/27(4)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST475	AB 06/04/27 (4)
10.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	SD 06/04/28 (4)

Job Completion



CYole/04/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

26080

Description: 206 Saddle, Inboard, Right side

Part Number:

D2933-2

Inspection Dwg: D2933 Rev. B

Page 1 of 1

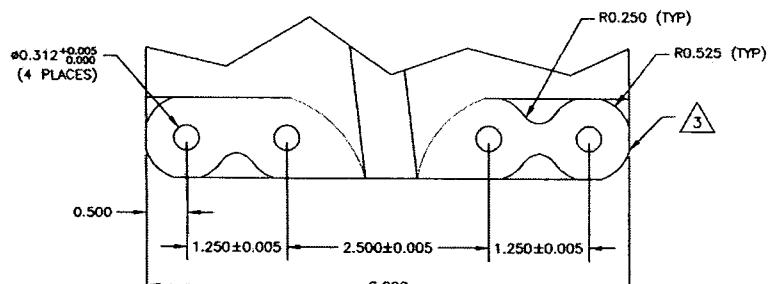
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.124	.123	.122		
B	0.100	0.140		.125	.123	.123	.122		
C	0.100	0.140		.123	.119	.118	.123		
D	0.210	0.230		.223	.221	.221	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.249	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.499	2.501		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.239	.238	.240	.239		
N	0.100	0.140		.118	.121	.117	.118		
O	0.540	0.560		.550	.550	.551	.548		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.719	3.720	3.718	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.251	.250	.251	.249		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.366	1.367	1.367		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.134	1.136	1.134	1.136		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

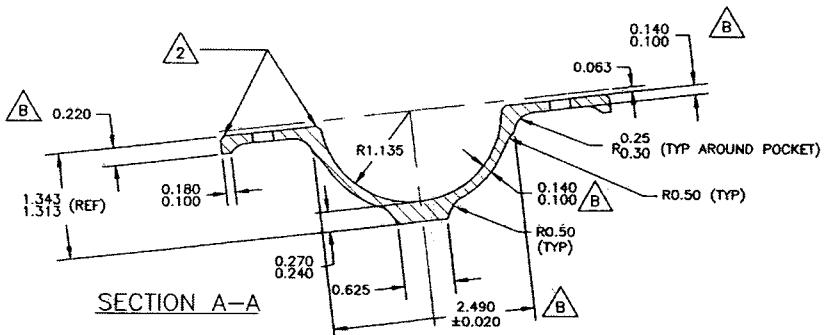
Measured by:	J.L.
Date:	06/04/20

Audited by:	E.P.
Date:	06/04/21

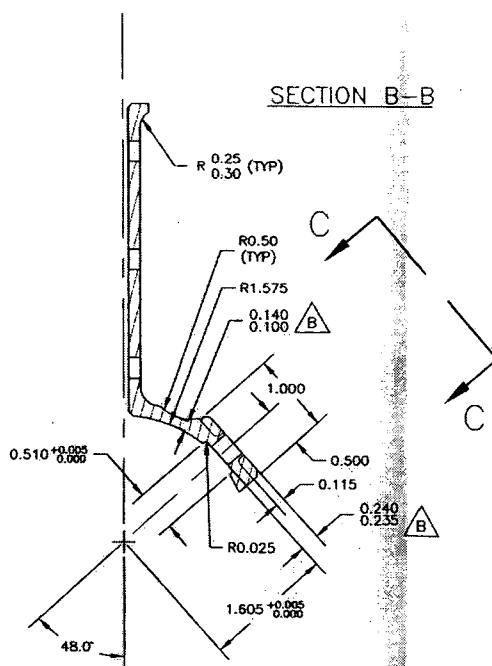
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	



VIEW C-C



SECTION A-A

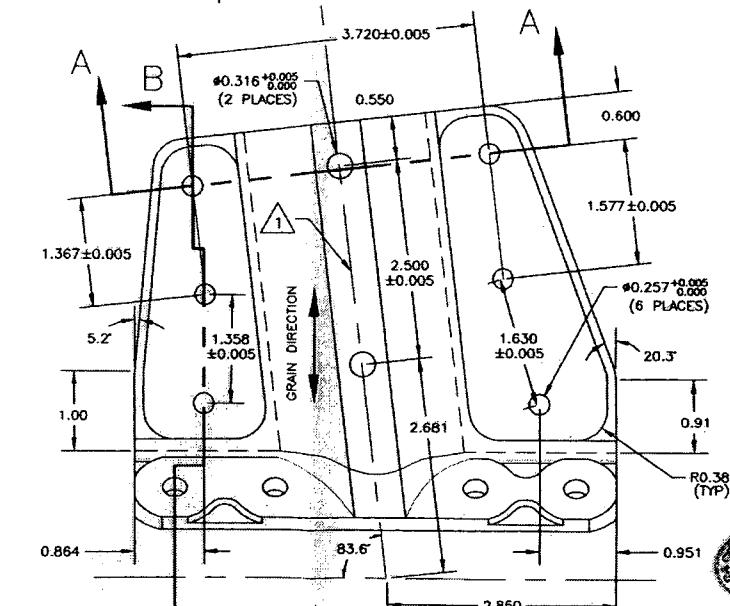


SECTION B-B

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO .0020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



RELEASED
05-31-97

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THAT IT MAY NOT BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2933 SHEET 1 OF 1
DATE	00.05.29	TITLE SADDLE INSIDE SCALE 2.3

SHOP COPY
RETURN TO
ENGINEERING
IN CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26080

Date: Friday, 4/28/2006 7:11:28 AM

User: Chantal Lavoie

**INVENTORY ITEMS PICKED
FOR SLIP NUMBER 2129**

Project No.	:	N/A	Drawing Number	:	D2933 REV B
Customer	:	Dart Helicopters Services	Drawing Name	:	206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Part Number	:	D29332	Due Date	:	/ /
Job Number	:	26080	Qty	:	4
			Slip #	:	2129

	Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0 D6101001 7075-T7351 2X6X6.25 Available 249.00		MAIN		24890	4.00	4.0000 Each	